

Work Order ID 132099

Friday, April 24, 2015 11:41:51 AM

132099

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Item ID: D2842-041

Revision ID:

Item Name: Step Assembly, 206 Float

Start Date: 4/24/2015 Start Qty: 4.00

Required Date: 4/24/2015 Req'd Qty: 4.00

Reference:

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: MLS Date: 15-04-24 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2842	Rev B

100

0.00

100

Large Fab

Large Fab

Large Fab

Memo

0.03

1-Cut D2842-1 using D2622 extrusion as per Dwg D2842

2-Drill D2842-1 using Jig DT8271 as per Dwg D2842 ***DO NOT OPEN

HOLES***

3-Deburr and bevel ends for welding

110

0.00

110

QC

Quality Control

QC- Inspect dimensions to drawing

Memo

0.00

DAS
 49
 9-89

15/05/25

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Item ID: D2842-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Step Assembly, 206 Float
Start Date: 4/24/2015 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 4/24/2015 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* Large Fab	Weld per dwg A/R Aluminum rod Batch: _____ Large Fab	0.00				4	0	150601	
	Memo	0.07							
Large Fab	1-Weld one end cap and (2) lugs using Jig DT10038 as per Dwg D2842								3E15-05-27
	2-Grind end cap weld flush								
	3- Open hole as per dwg and deburr(0.250")								
130 *130* QC	QC9- Inspect visual per QSI004- Fusion Welds	0.00							DAS 9 9-89
Quality Control	Memo	0.00				④	15-06-02		
140 *140* QC	QC5- Inspect part completeness to step on W/O	0.00							DAS 9 9-89
Quality Control	Memo	0.00				④	15-06-02		

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Item ID: D2842-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Step Assembly, 206 Float
Start Date: 4/24/2015 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 4/24/2015 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150						4x			
HandFinish	Memo	0.03							
Hand Finishing									
160	QC7-Inspect Chemical Conversion Coat	0.00							
160						(4)			DAS 38 9-89
QC	Memo	0.00							
Quality Control									
170	Weld per dwg A/R Aluminum rod Batch <u>M13037</u>	0.00							
170						4	8		BK 15-06-03
Large Fab	Memo	0.10							
Large Fab	1-Remove alodine prior to welding. Weld end cap as per Dwg D2842. 2-Grind end cap weld flush.								

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Item ID: D2842-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Step Assembly, 206 Float
Start Date: 4/24/2015 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 4/24/2015 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC10- Inspect visual per QSI004- ground welds	0.00							DAS 9 9-89
180									
QC	Memo	0.00							
Quality Control									
190	QC5- Inspect part completeness to step on W/O	0.00							DAS 9 9-89
190									
QC	Memo	0.00							
Quality Control									
191	Pressure Wash per QSI005 4.3	0.00							
191									
HandFinish	Memo	0.01							
Hand Finishing	***Touch up step with alodine per qsi 005 prior to powder coat***								

4 15-6-4

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Item ID: D2842-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Assembly, 206 Float
 Start Date: 4/24/2015 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 4/24/2015 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
200	<i>m 131545.</i>								
Powdercoat	Memo	0.01							
Powder Coating	START TIME: <i>10:20</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>12:50</i>								
210	QC3- Inspect Part Finish	0.00							
210									
QC	Memo	0.00							
Quality Control									
220	HandFinishing	0.00							
220									
HandFinish	Memo	0.04							
Hand Finishing	1-Install inserts as per Dwg D2842 2-Wing Walk as per Dwg D2842 and QSI 005 4.1 Batch: <i>ML37039</i>								

DAS
15
9-89

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Revision ID: Stop ***NS2***
Item Name: Step Assembly, 206 Float
Start Date: 4/24/2015 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 4/24/2015 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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230	QC5- Inspect part completeness to step on W/O	0.00							
230						(4)			DAS 38 9-89
QC	Memo	0.00							

Quality Control

JUN 09 2015

240	Identify as per dwg & Stock Location: _____	0.00							
240									
Packaging	Memo	0.00							

Packaging

129571 x2
132486 x1

DAS
6
9-89

JUN 09 2015

250	QC21- Final Inspection - Work Order Release	0.00							
250									
QC	Memo	0.01							

Quality Control

MCS

JUN 09 2015

MCS JUN 09 2015

Picklist Print

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Work Order ID: 132099

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Parent Item: D2842-041

D2842-041

Parent Item Name: Step Assembly, 206 Float

Start Date: 4/24/2015

Required Date: 4/24/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
NAS1149C0332R		Purchased		No		100	Each	3,998.000	3	12			
NAS1149C0332R									**				
WASHER													

Location

Loc Qty

Loc Code

FP001
123248
m130325
GA
m131618
ST260a
m131697
ST271
m131340

2174
34
2140
698
698
1102
1102
24
24

ML132262

x12

D2622-120C

Manufactured No

120 Each

151.9200

1

4

D2622-120C

Step Extrusion

Location

Loc Qty

Loc Code

WA003
125381
130161

151.92
25.92
126

4

D2734

Manufactured No

120 Each

89.0000

2

8

D2734

Step End Plate

Location

Loc Qty

Loc Code

WA003
130457
130983

89
29
60

8

BE15-05-26

DL 15/4/29

all 15/06/09

Picklist Print

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Parent Item: D2842-041

D2842-041

Parent Item Name: Step Assembly, 206 Float

Start Date: 4/24/2015

Required Date: 4/24/2015

Start Qty: 4.00

Required Qty: 4.00

D3459-3

Manufactured No

120

Each

48.0000

2

8

D3459-3

Float Step Mounting Plate

B/E 1505-26

Location

Loc Qty

Loc Code

WA003

48

125129

6

125762

6

126298

6

129735

10

130491

20

4

4

D3459-1

Manufactured No

220

Each

41.0000

2

8

D3459-1

Float Step Mounting Plate

B/E 1506-26

Location

Loc Qty

Loc Code

WA003

41

125766

6

126297

6

130003

12

130490

17

4

4

MS27039C1-07

Purchased No

220

Each

68.0000

3

12

MS27039C1-07

screw

12 15/06/09

Location

Loc Qty

Loc Code

ST283

68

m130566

18

m131624

50

X6

X6

Picklist Print

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Parent Item: D2842-041

D2842-041

Parent Item Name: Step Assembly, 206 Float

Start Date: 4/24/2015

Required Date: 4/24/2015

Start Qty: 4.00

Required Qty: 4.00

NAS1329C3KB130

Purchased

No

220

Each

63.0000

3

12

NAS1329C3KB130

Insert

all 15/06/09

Location

Loc Qty

Loc Code

FP001

23

m129207

21

m130281

2

ST267

40

131677

40

✓

X3

12

NAS1515H3L

Purchased

No

220

Each

367.0000

3

12

***NAS1515H3I ***

Washer

all 12/06/09

Location

Loc Qty

Loc Code

FG

40

102472

40

FP001

55

m127831

55

ST266

272

m127831

48

m130726

224

X12

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QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2842-041	LH STEP ASSEMBLY
	X	D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN980C10L	WASHER

Technical drawing showing a cross-section of a structural member. A circular detail is highlighted with a 45.0 degree angle. The drawing is labeled "D2734 END PLATE".

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

TYPICAL STEP END DETAIL
NOT TO SCALE

NO. 132090

1504-5113

—REFER TO
END DETAIL

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004

CHECKED		APPROVED	DRAWING NO.	REV. A
KE		PH	D2842	SHEET 1 OF 1
DATE		TITLE		
05.09.23		206L/407 FLOAT STEP ASSEMBLY		
A	98.10.13	NEW ISSUE		
B	05.09.23	RE-DESIGN, ADD D3459-1/-3		

8-11-5

RELEASED